

Date: Tuesday, 10/06/2008 3:14:29 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE ASSEMBLY
<b>Job Number</b> :	39803		
<b>Estimate Number</b> :	11180		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2282043
<b>This Issue</b> :	10/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2282 REV E
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38606B	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JLD 08.6.10	<b>Due Date</b> :	30/06/2008
<b>Comment</b> :	Est Rev:A Removed from 9 Digit 05-12-02 JLM	<b>Qty:</b>	50 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2281

Jack Saddle



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2281

Saddle

B37445

→ 38x ✓

B39817

→ 12x ✓

EL 8-7-25

(50)

2.0

D22827

Tube



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2282-7

tube

b37850 x 91 ✓

9x 32474

35474

(100)

EL 8-2-25

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

A/R ER316L SS

Filling Rod

M101 744

Dwg Rev: E

EL 8-8-5

(50)

4.0

QC9

VISUAL WELDING INSPECTION



**Comment:** VISUAL WELDING INSPECTION

D 08-08-2 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 39803

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes  
2-tumble

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-21

**Dart Aerospace Ltd**

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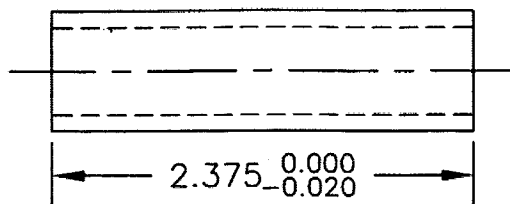
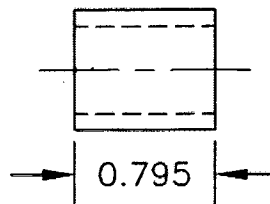
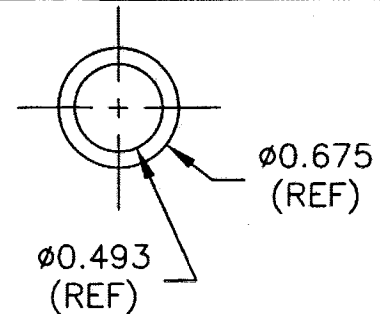
**NOTE:** Date & initial all entries

**DART**

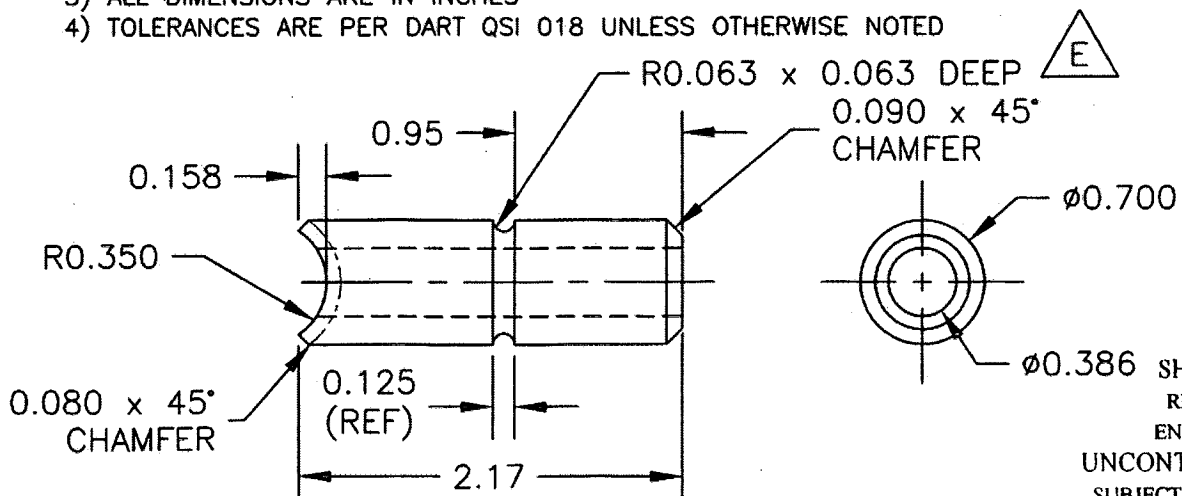
DESIGN BW	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**RELEASED**

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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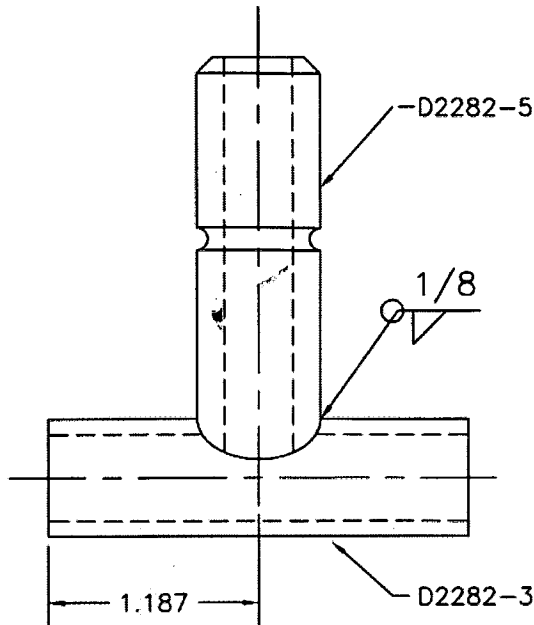
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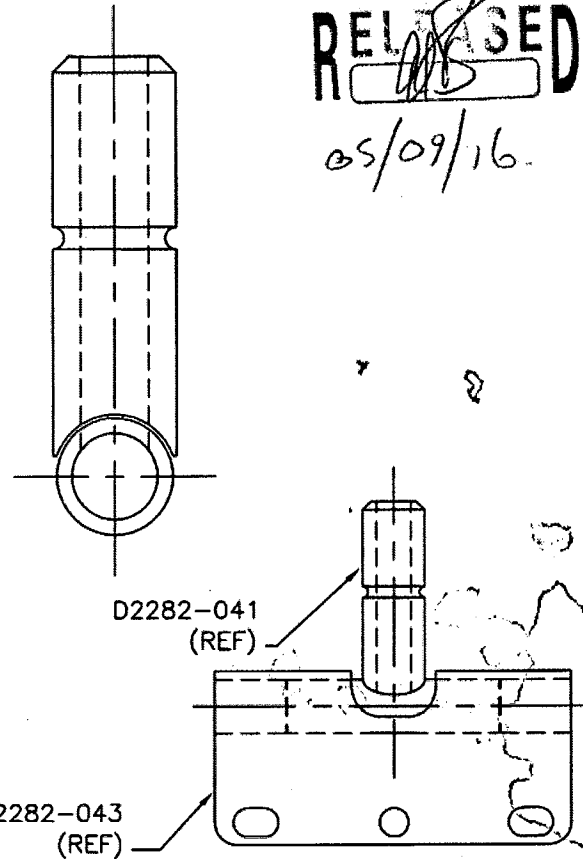
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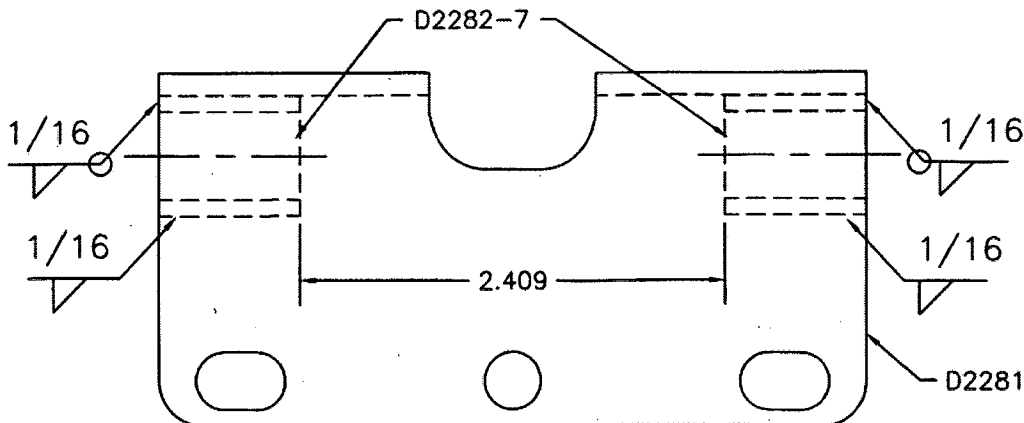
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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